

Thursday, February 05, 2015 12:39:26 PM

1 29392

Page 1

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Bracket

Start Date: 2/5/2015 **Start Qty:** 2.00 ***2***

Cust Item ID:

Required Date: 2/5/2015 **Req'd Qty:** 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: MLS Date: 15-02-05 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run	Start	*NR1*
	Stop	*NR2*

100		0.00		DAS
100	BAND SAW			14
Bandsaw		0.00	mt 15/02/06 2 v	9-89
Jeaspa Bandsaw	Memo Cut blanks at 2.00"			

110		0.00			DAS
110	HAAS CNC VERTICAL MACHINING #1		<i>L.A.</i>	<i>15/02/07</i>	08
HAAS 5AXIS	Memo	0.00		<i>2</i>	9-89
HAAS CNC vertical machine #5	Machine per folio FB363			<i>φ</i>	
	Folio rev: <u>AA</u>				
	Dwg. rev: <u>A</u>				

Thursday, February 05, 2015 12:39:26 PM

1 29392

Page 2

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 2/5/2015 **Start Qty:** 2.00 ***2***

Cust Item ID:

Required Date: 2/5/2015 **Req'd Qty:** 2.00 ***Q***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run	Start	*NR1*
	Stop	*NR2*

**Insp.
Stamp**

0.00

120

QC

Memo

0.00

Quality Control

D. 15/02/07

2

 ϕ

DAS
08
9-89

0.00

130

OC

Memo

0.00

Quality Control

2

~~1~~

DAS
20
9-89 15-02-09

0.00

160

HandFinish

Memo

0.00

Hand Finishing

2

15-2-112

Work Order ID 129392

Thursday, February 05, 2015 12:39:26 PM

129392

Page 3

Item ID: D5204-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket
 Start Date: 2/5/2015 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 2/5/2015 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
165	QC7-Inspect Chemical Conversion Coat	0.00							
165						2	0	15-2-12	DAS 34 9-89
QC	Memo	0.00							
Quality Control									
170	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
170	M 12948					2	0	15-2-12	DAS 34 9-89
Powdercoat	Memo	0.00							
Powder Coating	-Mask holes as per dwg.								
	START TIME: 10:05 OVEN TEMPERATURE:								
	FINISH TIME: 10:35								
180	QC3- Inspect Part Finish	0.00							
180						2			DAS 38 9-89
QC	Memo	0.00							
Quality Control									

FEB 13 2015

Work Order ID 129392

Thursday, February 05, 2015 12:39:26 PM

129392

Page 4

Item ID: D5204-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket
 Start Date: 2/5/2015 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 2/5/2015 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: <u>5151</u>	0.00							
190									
Packaging	Memo	0.00							
Packaging									
200	QC21 - Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

2
 DAS
 05
 9-09
 FEB 11 2015
 15/2/18
 15.2-18

Picklist Print

Thursday, February 05, 2015 12:39:31 PM

Page 1

Work Order ID: 129392

129392

Parent Item: D5204-3

D5204-3

Parent Item Name: Bracket

Start Date: 2/5/2015

Required Date: 2/5/2015

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev: A RQ Verified by DD 15.01.23

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.500X02.00 0		Purchased	No			100	f	7.9000	0.083	1			

M6061T6B1 500X02 000

**

6061-T6 Bar 1.50 x 2.00

Location

Loc Qty

Loc Code

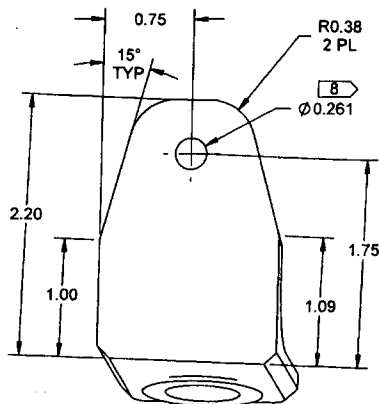
MAT004

7.9

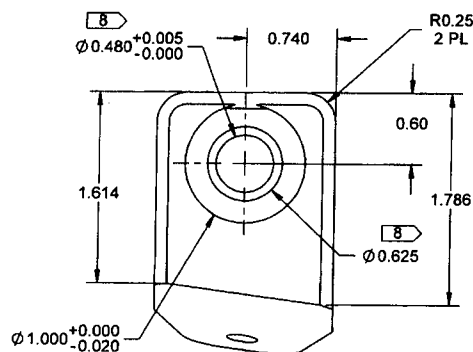
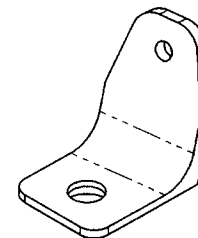
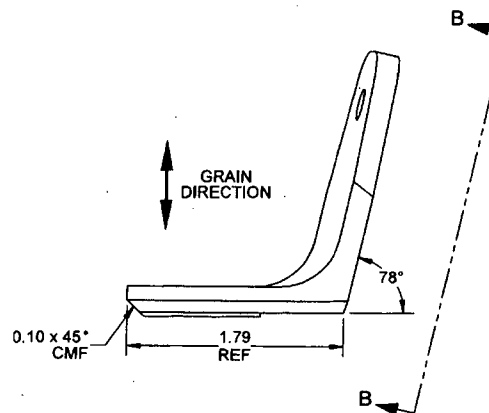
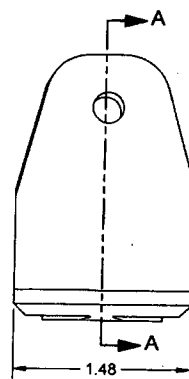
m126726

7.9

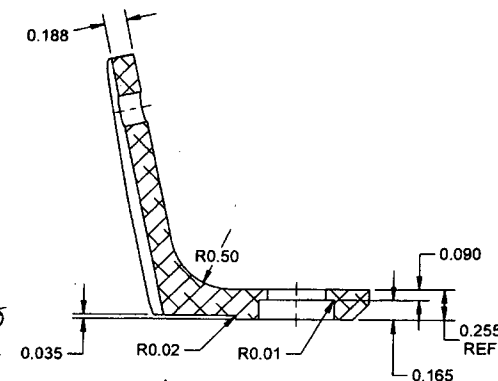
40 m 15/02/06



VIEW B-B



D5204-1 BRACKET



SECTION A-A

NOTES:

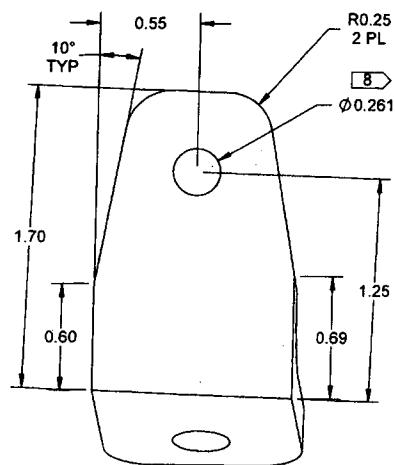
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.10 lbs
- 8) MASK HOLES PRIOR TO POWDER COAT

RELEASED

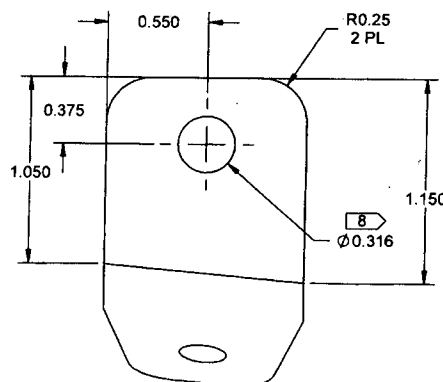
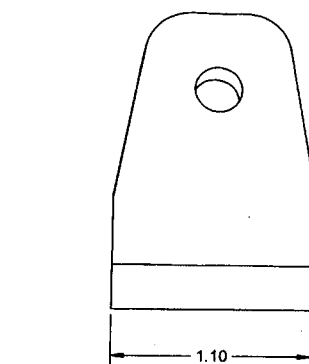
2015 JAN 29
ECN 15-508 9

APPROVED

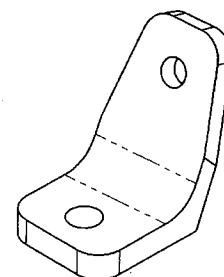
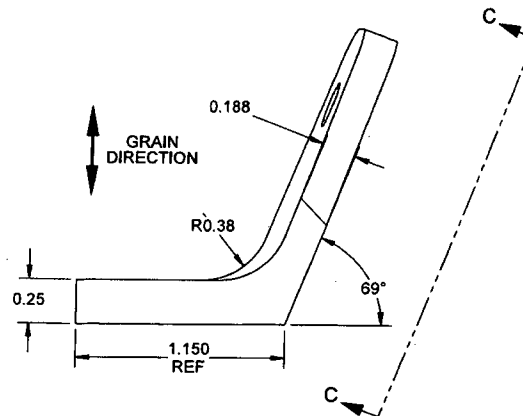
A		NEW ISSUE		RF	14.12.19
REV.	DESCRIPTION			BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	RF				
CHECKED	AK	DRAWING NO.	REV. A		
MFG. APPR.	RQ	D5204	SHEET 1 OF 2		
APPROVED	HS	TITLE	SCALE		
DE APPR.	DS	BRACKET	NTS		
DATE	14.12.19	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



VIEW C-C



D5204-3 BRACKET



NOTES:

- 1) MATERIAL: 6061-T6/T651/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.05 lbs
- 8) MASK HOLES PRIOR TO POWDER COAT

RELEASED

2015 JAN 29

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	AK	DRAWING NO.	REV. A
MFG. APPR.	RQ	D5204	SHEET 2 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BRACKET	NTS
DATE	14.12.19	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	